

Date: Tuesday, 03/03/2009 4:12:18 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services

Drawing Name : 412 WEB

Job Number : 46255

Estimate Number : 10466

P.O. Number :

Part Number : D33891

This Issue : 03/03/2009 S.O. No. :

Drawing Number : D3389 REV D

Prsht Rev. : NC

Project Number : N/A

First Issue : / / Type : SKIDTUBES

Drawing Revision : D

Previous Run : 44577

Material :

Due Date : 16/03/2009 Qty: 1 Um: Each

Written By :

Checked & Approved By :

Comment :

: Est Rev:A 05.08.31 New issue KJ/JLM

Est Rev:B 06-02-08 As per Rev C JLM

Est Rev:C 07-11-13 ECN 1056 Rev D dwg DD verified

by:EC

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

D25003100

Ext'n - 'I' Beam Web 4"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Ext'n - 'I' Beam Web 4"

Pick:

Qty	Part Number	Description	Batch
1	D2500-3-100	Web Extrusion	B-40196

AWM ①
9-4-20

2.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut to length as per Dwg D3389

2-Drill pilot holes using DT8785 as per Dwg D3389

3-Open holes to finish size as per Dwg D3389

4-Deburr

AWM 9-4-21 ①

3.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

BE 09/04/21 ①

4.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

AWM 9-4-21 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: 412 WEB

Job Number: 46255

Part Number: D33891

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ET 09-04-21

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

L-G.

AWM 9-4-21

(1)

7.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/22 JG

Job Completion



ME
09-04-21

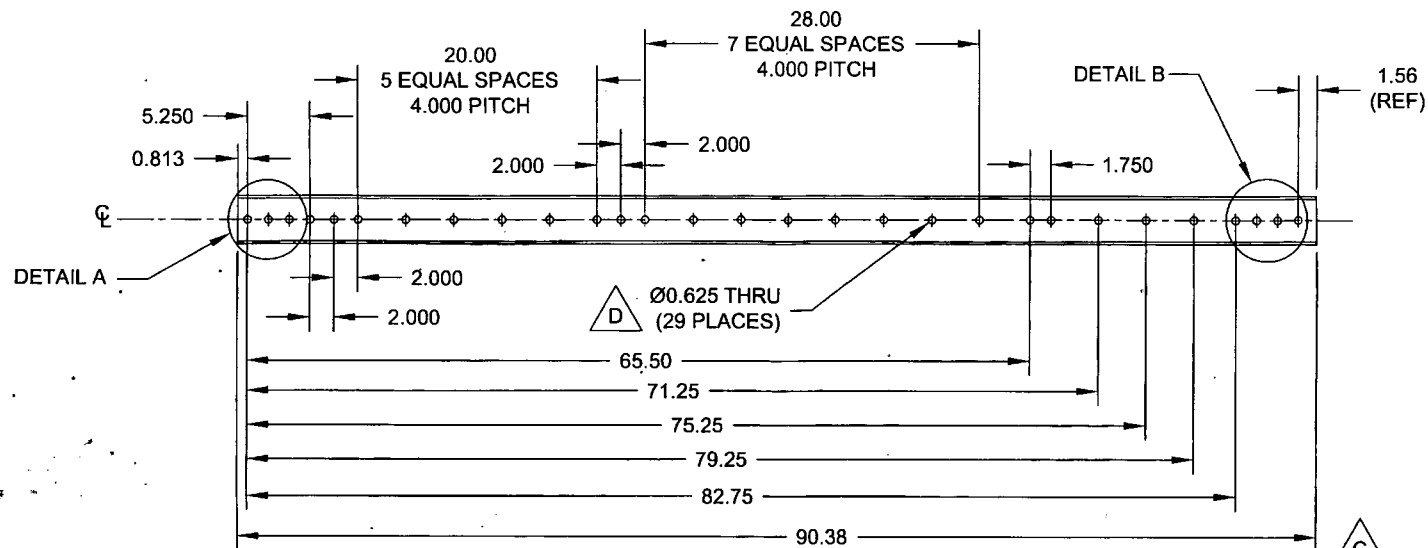
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

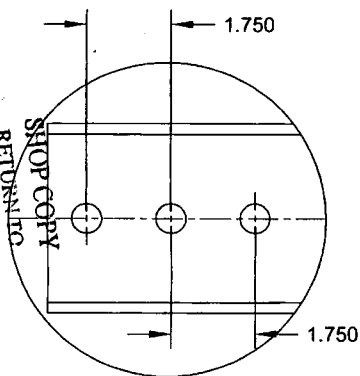
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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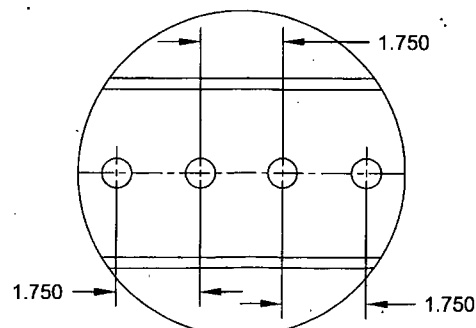
NOTE: Date & initial all entries



D3389-1 412 WEB



DETAIL A
SCALE 2:5



DETAIL B
SCALE 2:5

- NOTES:**
- 1) MATERIAL: MAKE FROM D2500-3 EXTRUSION
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.010 TO 0.020 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 6.6 lbs

RELEASED
07.11.06 MJD

D	REVISE HOLE DIAMETER FROM Ø0.257 TO Ø0.625, ZONE D4; REFORMAT DRAWING	PH	07.10.09
C	DECREASE OVERALL LENGTH, MODIFY HOLE	PH	06.01.23
B	UPDATE DIMENSIONING	PH	05.06.13
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	07.10.09		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO. D3389	REV. D
TITLE 412 WEB	SHEET 1 OF 1
SCALE 1:10	

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